

# Work Order ID 86214

\*86214\*

Page 1

June-22-12 3:43:44 PM

Item ID: D3147-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Pin

Stop \*NS2\*

Start Date: 22/06/2012 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/25 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3147

Rev C

100

0.00

\*100\*

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA691 & DWG D3147

FOLIO REV: N/A

DWG REV: C

2-DEBURR AS REQUIRED

DAS  
13  
2-89

12/7/27

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

DAS  
13  
2-89

12/7/27

13

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
14  
2-89

12/07/27

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86214

**\*86214\***

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June-22-12 3:43:44 PM

Item ID: D3147-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Pin

Start Date: 22/06/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 30

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

13

12/7/31

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/7/31

MCS 12/07/130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

June-22-12 3:43:49 PM

Page 1

Work Order ID: 86214

\*86214\*

Parent Item: D3147-1

\*D3147-1\*

Parent Item Name: Pin

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev A New Issue 07-01-26 JLM  
 IPP Rev:B Now on Cnc 07-05-02 JLM  
 IPP Rev:C Now on Doosan 08-10-14 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.187		Purchased	No			100	f	14.8300	0.225	2.842105			

\*M303R0 187\*

303 Round Bar 0.187"

\*\*

DAS  
13  
9-89

12/7/27

Location

MAT028

114968

120349

Loc Qty

14.83

7.83

7

Loc Code

2.1 Lt

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

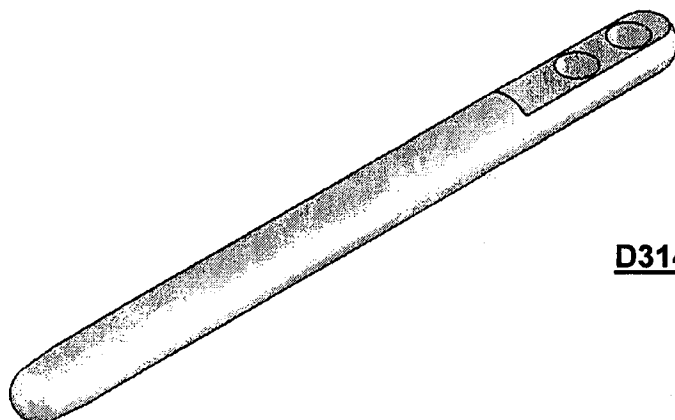
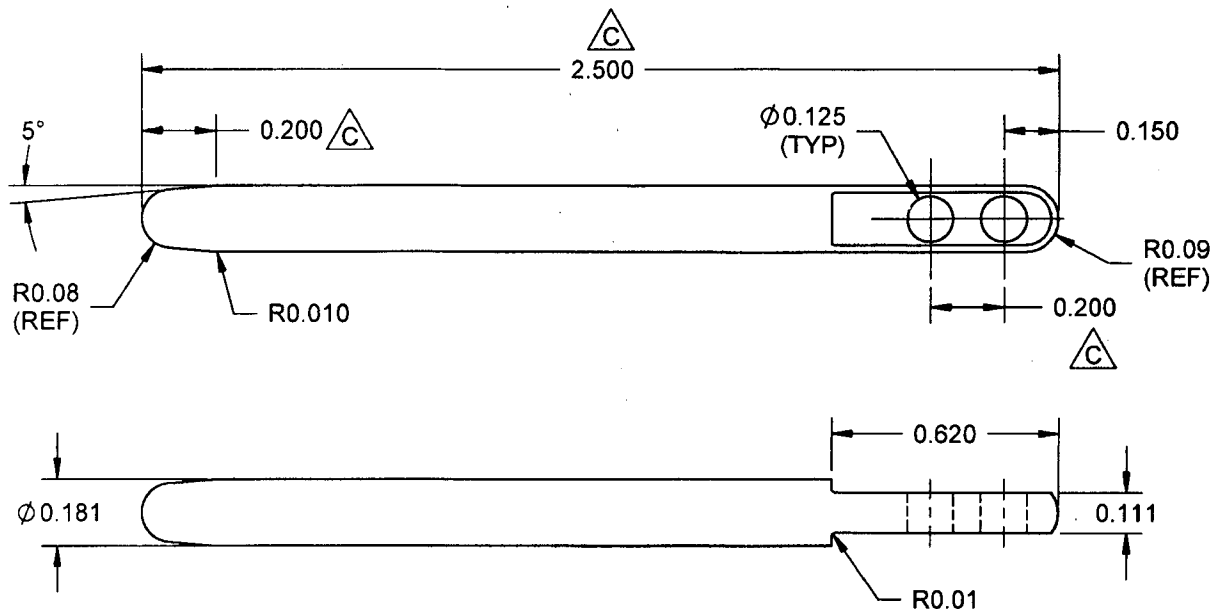
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**DART**

DESIGN #	DRAWN BY JH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED JH	DRAWING NO. <b>D3147</b>	REV. C SHEET 1 OF 1
DATE <b>06.12.04</b>	TITLE <b>PIN</b> SCALE 2:1		
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND $\phi 0.125$ HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	

**D3147-1 PIN**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86214 M45  
12/06/25  
**RELEASED**  
07-01-22

**NOTES:**

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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